

Application No. 09/658,763  
Amendment dated June 10, 2004  
Reply to Office Action of May 18, 2004

**Amendments to the Specification:**

Please replace page 9 of the Specification, as follows:

with the manifolds successively operated at 100, 300, 800 and 800 psi , at a line speed of 50 feet per minute.

The entangling apparatus of FIGURE 1 further includes an imaging and patterning drum 18 comprising a three-dimensional image transfer device for effecting imaging and patterning of the now-entangled precursor web. The entangling apparatus includes a plurality of entangling manifolds 22 that act in cooperation with the three-dimensional image transfer device of drum 18 to effect patterning of the fabric. In the present example, the three entangling manifolds 22 were operated at 1900 psi, at a line speed which was the same as that used during pre-entanglement.

The three-dimensional image transfer device of drum 24- 18 was configured as a so-called octagon and square, as illustrated in FIGURES 4, 4a, 4b, and 4c.

Subsequent to patterned hydroentanglement, the fabric was dried on three consecutive steam cans at 300° F at 26, then received a substantially uniform application by dip and nip saturation of a pre-dye finish composition at application station 30. The web was then directed through a tenter apparatus 32, operated at 300°F.

In the present example, the pre-dye finish composition was applied at a line speed of 50 feet per minute, with a nip pressure of 40 psi and percent wet pick up of approximately 120%.

The pre-dye finish formulation, by weight percent of bath, was as follows: